

Purchase Order Receipt Listing

Page 1 of 1

Wednesday, June 11, 2014 8:15:10 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO24446 Receipt Dates from 6/11/2014 to 6/11/2014 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-COP001	Thyssenkrupp Materials CA Ltd								
PO24446	1		M304S16GA	sf	6/9/2014	6/11/2014	320.0000	\$4.18	0.0000	0	\$1,337.34
CAD	No		304/316 Sheet .063	sf	320.0000	DESJ02		\$1,337.34	0.0000	0	
			m129449								
	2		M6061T6B0.500X05. f		6/9/2014	6/11/2014	48.0000	\$5.52	0.0000	0	\$264.74
	No		6061-T6 Bar .500 x f		48.0000	DESJ02		\$264.74	0.0000	0	
			5.00								
			m129449								
	3		71401-45		6/9/2014	6/11/2014	1.0000	\$0.00	0.0000	0	\$0.00
	No		PROCUREMENT		1.0000	DESJ02		\$0.00	0.0000	0	
			QUALITY CLAUSES								
			m129449								
Total Received Quantity:										369.0000	
Total Qty to Inspect (PO U/M):										0.0000	
Total Reject Quantity:										0.0000	
Total Receipt Value:										\$1,602.08	
Total Balance Due Quantity:										0.0000	

24

B I L L O F L A D I N G

No: PEC 881185

Ship From:
 THYSSENKRUPP MATERIALS NA
 2821 LANGSTAFF ROAD
 CONCORD, ONTARIO L4K 5C6
 Tel: 905 669 9444 Fax: 905-738-9033

Ship Date 09 Jun 14 at 10:39 From PFW
 Probill
 Via VIM TRANSFER
 FOB CONCORD
 Frt PREPAID
 Route 0- 0 Manifest
 Vhcle Trailer
 Slp STAN IVERS (905-532-1350)
 Sold To: (20115)
 DART AEROSPACE
 1270 ABERDEEN ST
 HAWKESBURY, ON K6A 1K7

Ship To: (1)
 DART AEROSPACE
 1270 ABERDEEN ST
 HAWKESBURY, ON K6A 1K7
 Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G

1) Our Order PEC-689051- 1 Your PO # 24446
 STAINLESS STEEL SHEET 304-2B
 .0600 Nom X 48.0000" X 96.0000"

Heat Number Tag No
 884227 300212

Quantity PCS Wt LBS
 320.00 SFT 10 768

2) Our Order PEC-689051- 2 Your PO # 24446
 ALUMINUM FLAT BAR 6061-T6511
 .50" x 5.00" X 144.0000"

Heat Number Tag No
 167476-3 299707

Quantity PCS Wt LBS
 48 FT 4 143

TOTAL: Tags PCS LBS
 2 14 911

Heat Number
 167476-3
 884227

*** Chemical Analysis ***

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
 WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
 TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
 ** REFERENCED ON IT **

TOTAL 1 SKID, 1 BDL G.W .1048 LBS

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
 RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
 MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

SHIP FROM: THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 905-738-9033

SHIP TO: (1)
DART AEROSPACE

NO: PEC 881185
SHIP DATE 09Jun14 at 10:39 From PFW
PROBILL
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE

B I L L O F L A D I N G

ITEM (1) SKID
ITEM (2) BDL

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

* WE STOCK STAINLESS STEEL *
* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

Page: 2 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

THYSSENKRUPP MATERIALS NA

Certificate of Mill Test Results

DART AEROSPACE

STAINLESS STEEL SHEET 304-2B

.0600 Nom X 48.0000" X 96.0000"

PART NO.

PO/Rel 24446

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

BL PEC-881185-001

SJun14

Signed by: Pg 1/1

Hersteller / Manufacturer's name / Usine productrice outokumpu		Artikel / Description / Type of material / Matière ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION nach / according to / suivant EN 10204-3.1		Bescheinigungs-Nr. / Certificate No. / Numéro de certificat 1000496333 / Seite / Page / Page 1 / 1																							
Adresse / Address / Adresse Oberschlesienstrasse 16, 47807 Krefeld OUTOKUMPU STAINLESS USA, LLC 1 Thyssenkrupp Drive CALVERT, ALABAMA AL 36513-1300 USA		Hersteller/Erzeuger / Manufacturer / Usine / Fabricant OUTOKUMPU STAINLESS USA, LLC, Calvert, Ala Kundenbest.-Nr. / Customer's order number / Numéro de commande du client 51004304 Werkzeugsymbol / Manufacturer's work order no. / N° de commande de l'usine productrice 900453432 / 001 Lieferungs-Nr. / Delivery Note No. / Avis d'expédition 87627406 / 010 Bezeichnung / Product / Produit BLECH / SHEET / TOLE																									
Lieferbedingungen / Terms of delivery / Conditions de livraison ASTM A 688 ASTM A 242/A 240M ASTM A 242/A 240M ASME SA 240/SA 240M Sec. II Part A Ed. 2013		Standards und Gütegrad / Standards and quality Type 304																									
Nennmaß / Nominal size / Dimensions nominales N° de matière du client P003389		Technische Zeichnungs-Nr. / Tech. / Design / Range / Product dimensions (Thickness / Width / Length) / Dimensions du produit (Epaisseur / Largeur / Longueur) 0.0579 inch x 48.0000 inch x 96.0000 inch		Herstell- Produktions- Stelle / Place of origin AOD																							
Peak Nr. / Peak No. / N° de pic 8702379 8702380		Stacksart / Kind of process / N° du procédé S2 S2		Masse / Weight / Masse effective 4.017 lbs 3.995 lbs																							
Masse / Weight / Masse effective 8.012 lbs		Mer.-Nr. / Erzeugnis- Ident.-Nr. et numéro dal. / N° du produit 278676 278676		Schmelz- nummer / Id. de la coulée 884227 884227																							
Proben- ID / Sample ID 1002875783 1002875784		Proben- ID / Sample ID 1002875783 1002875784		Proben- ID / Sample ID 1002875783 1002875784																							
Chemische Zusammensetzung / Chemical composition <table border="1"> <thead> <tr> <th>Standard / Cus- tomer</th> <th>% C</th> <th>% Si</th> <th>% Mn</th> <th>% P</th> <th>% S</th> <th>% Cr</th> <th>% Ni</th> <th>% N</th> <th>% Mo</th> <th>% Cu</th> </tr> </thead> <tbody> <tr> <td>884227</td> <td>0.033</td> <td>0.38</td> <td>1.28</td> <td>0.027</td> <td>0.0040</td> <td>18.13</td> <td>8.50</td> <td>0.040</td> <td>0.20</td> <td>0.44</td> </tr> </tbody> </table>						Standard / Cus- tomer	% C	% Si	% Mn	% P	% S	% Cr	% Ni	% N	% Mo	% Cu	884227	0.033	0.38	1.28	0.027	0.0040	18.13	8.50	0.040	0.20	0.44
Standard / Cus- tomer	% C	% Si	% Mn	% P	% S	% Cr	% Ni	% N	% Mo	% Cu																	
884227	0.033	0.38	1.28	0.027	0.0040	18.13	8.50	0.040	0.20	0.44																	
Prüfungsbericht / Test report / Rapport d'essai Proben-ID / Sample ID 1002875783 1002875784																											
Wärmebehandlung / Heat treatment / Traitement thermique 1050 GRAD C / 1050 1050 GRAD C / 1050 1050 DEGREE / 1050																											
Unterschrift / Signature / Signature Outokumpu Nirosta GmbH Dieses Zeugnis wurde maschinell erstellt Work Krefeld																											
Datum der Ausstellung und Gültigkeit / Date of issue and validity 13.11.2013																											

THYSSENKRUPP MATERIALS NA

DART AEROSPACE

ALUMINUM FLAT BAR 6061-T6511
.50" x 5.00" X 144.0000"
PART NO.

PO/Rel 24446

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Signed by: _____

Certificate of Mill Test Results

BL PEC-881185-002

5Jun14

Pg 1/1



TEL: (416)745-4444 FAX: (416)745-0925 1-800-668-7210
411 CHRISLEA ROAD, WOODBRIDGE, ONTARIO, CANADA L4L 8N4
<http://www.extrudex.com>

MILL TEST ASTM B221

BILL TO	17.3 CERT CODE:	DIE NUMBER	DATE OF SHIPMENT	EXTRUDEX ORDER NO.	MANIFEST NO.
THYSSENKRUPP MATERIALS, NA	1 0.59	S 4768	Apr/10/2014	167476 - 3	305771
SHIP TO	CUSTOMER PO	ALLOY	TEMPER	SALESMAN	
THYSSENKRUPP MATERIALS, NA	PEC-256997	6061	T6511	FORBES DODWELL	MADE IN CANADA
SO DESCRIPTION	CUSTOMER PART NUMBER	PART DESCRIPTION	CERTIFICATION		
.500"x5" FB	4768-S	.500"x5" FB	MILL TEST ASTM B221-13		

Mechanical Properties

Lot	Alloy	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation	Hardness	Conductivity
A.11	6061	Apr/08/2014	42.90	38.70	12.50	87.8, 88.3, 88.0	

Chemical Composition

Cast Number	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Ga	V	B	Zr	Bi	Pb	Sn	Sr	Co	Al	Other
A.11 2BW686 6061	0.64	0.17	0.21	0.03	0.9	0.07	0	0.01	0.01	0	0	0	0	0	0	0	0	0	0	0.03

We certify that the following extrusions have been quality inspected/tested and conforms to required dimensional and temper specifications.

27
9-19
4/6/11

David Natale
Quality Control Manager

1 - CUSTOMER COPY

MILL TEST ASTM B221



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24446

Purchase Order Date 6/3/2014

PO Print Date 6/3/2014

Page Number 1 of 2

Order From : VC-COP001
THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905 669 9444	Customer POID	
Ship To Contact		Customer Tax #	10127-2607
Ship To Phone		Terms	Net 30
Ship Via:	VENDOR'S TRUCK	Currency	CAD
Ship Acct:		FOB	FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	M304S16GA	304/316 Sheet .063	6/9/2014 Yes 6/9/2014		320.00 ✓ sf	\$4.53	\$1,450.00
MATERIAL; AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240							
Line Total:							\$1,450.00
2	M6061T6B0.500X05.000	6061-T6 Bar .500 x 5.00	6/9/2014 Yes 6/9/2014		48.00 ✓ f	\$5.98	\$287.04
MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221							
Line Total:							\$287.04

SP14-6-11

PO Instructions: NO: PEC ST-688841

Note:

6/3/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24446**

Purchase Order Date 6/3/2014

PO Print Date 6/3/2014

Page Number 2 of 2

Order From : VC-COP001
THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905 669 9444

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

3	71401-45	PROCUREMENT QUALITY CLAUSES	6/9/2014	1.00	✓	\$0.00	\$0.00
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No

6/9/2014

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality document

SP14-6-11

Line Total: \$0.00

PO Total: \$1,737.04

PO Instructions: NO: PEC ST-688841

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 6/3/2014

CL mb

Q U O T A T I O N

No: PEC ST-688841

Quoted By:

THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 905-738-9033

Quoted To: (20115)

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Quoted Ship To: (1)

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Trm NET 30 DAYS/NET 30 JOURS Qtd 03Jun14 Qte Ref
Frt PREPAID Via FOB
Tel 613-632-9577 Fax 613-632-1053 Ctc CHANTAL
Slp STAN IVERS (905-532-1350)

Q U O T A T I O N

QT No: PEC ST-688841

Test Certs: Chem-Y Phys-Y 1 Original copies with Shipment, 1 with Invoice

1 STAINLESS STEEL SHEET 304-2B	10 PCS	802 LBS
.0600 Nom X 48.0000" X 96.0000"		
MATERIAL	10 PCS @	145.0000 EA
ENERGY & CAP SURCHG		25.0000 LOT
		25.00
2 ALUMINUM FLAT BAR 6061-T6511	4 PCS	144 LBS
.50" x 5.00" X 144.0000"		
MATERIAL	48 FT @	5.9800 FT
		287.04

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.

ATTN: CHANTAL/LINDA

** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **

** REFERENCED ON IT **

Price in effect at time of shipment.

Price based on receipt of total order.

All weights are theoretical.

All orders are subject to credit approval.

**** TEL. 800-926-2600 ****

*** CUSTOMER PICK-UP HOURS ***

*** 9:00 AM TO 4:00 PM ***

* WE STOCK STAINLESS STEEL!!!! *

* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A \$25.00 ENERGY SURCHARGE WILL BE

ADDED TO EVERY ORDER.***

*FOR OUR FULL SALES TERMS AND CONDITIONS, PLEASE

*VISIT OUR WEBSITE: www.copperandbrass.com

Order Totals: 2 Items 946 LBS

Material	Processing	Freight	Other	Taxes	ORDER AMT
1,737.04			25.00	229.07	1,991.11

Page: 1Continued

Q U O T A T I O N

No: PEC ST-688841

Quoted By:
 THYSSENKRUPP MATERIALS NA
 2821 LANGSTAFF ROAD
 CONCORD, ONTARIO L4K 5C6
 Tel: 905 669 9444 Fax: 905-738-9033

Quoted To: (20115)
 DART AEROSPACE

Quoted Ship To: (1)
 DART AEROSPACE

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=====
                        Q U O T A T I O N                        QT No: PEC ST-688841
*****
Taxes: ONHSTS      229.07                        0.00                        0.00                        0.00
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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304S16GA

PO / BATCH NO.: 24446

DATE: JUN 11 2014

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 10
 QUANTITY INSPECTED: 10
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.63
 THICKNESS RECEIVED: 0.615
 SHEET SIZE ORDERED: 48" x 96"
 SHEET SIZE RECEIVED: 48" x 96"

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	<input checked="" type="radio"/> N	
CORRECT FINISH	<input checked="" type="radio"/> Y	N	
CORROSION	Y	<input checked="" type="radio"/> N	
CORRECT GRAIN DIRECTION	<input checked="" type="radio"/> Y	N	
CORRECT MATERIAL	<input checked="" type="radio"/> Y	N	
CORRECT THICKNESS	<input checked="" type="radio"/> Y	N	
PHOTO REQUIRED	Y	<input checked="" type="radio"/> N	
CORRECT MATERIAL	<input checked="" type="radio"/> Y	N	
CORRECT REF # TO LINK CERT	<input checked="" type="radio"/> Y	N	HT # 884221
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="radio"/> Y	N	ASTM SA 240
CORRECT M# ON THE MATERIAL	<input checked="" type="radio"/> Y	N	M169449
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	<input checked="" type="radio"/> N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	<input checked="" type="radio"/> N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>27</u> <u>9-89</u>	SIGNED OFF BY: _____	
DATE: <u>4/6/11</u>	DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORR DINATOR BEFORE GOING FURTHER

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M6061 T6 B3, Saw X 5.000

PO / BATCH NO.: 24446

DATE: JUN 11 2014

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 4
 QUANTITY INSPECTED: 4
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .50 X 5.00
 THICKNESS RECEIVED: .511 5.02
 SHEET SIZE ORDERED: 48 54
 SHEET SIZE RECEIVED: 48 54

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	<input checked="" type="radio"/> N	
CORRECT FINISH	<input checked="" type="radio"/> Y	N	
CORROSION	Y	<input checked="" type="radio"/> N	
CORRECT GRAIN DIRECTION	<input checked="" type="radio"/> Y	N	
CORRECT MATERIAL	<input checked="" type="radio"/> Y	N	
CORRECT THICKNESS	<input checked="" type="radio"/> Y	N	
PHOTO REQUIRED	Y	<input checked="" type="radio"/> N	
CORRECT MATERIAL	<input checked="" type="radio"/> Y	N	167476-3
CORRECT REF # TO LINK CERT	<input checked="" type="radio"/> Y	N	ASTM B221-13
CORRECT MATERIAL IDENTIFICATION	<input checked="" type="radio"/> Y	N	m127449
CORRECT M# ON THE MATERIAL	<input checked="" type="radio"/> Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	<input checked="" type="radio"/> N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	<input checked="" type="radio"/> N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>27 9-89</u> DATE: <u>JUN 11 2014</u>	SIGNED OFF BY: _____ DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORR DINATOR BEFORE GOING FURTHER